

Work Order ID 68447

Wednesday, April 13, 2011 2:29:11 PM



Ship ASAP.

Page 1

Item ID: D350-689-015

Accept



Setup Start



Revision ID:

Item Name: Seat Modification

Stop



Start Date: 4/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: UMF Date: 11-04-13 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3033	Rev A1								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile per DSI 9222 and create labels per PPP D350-689-015
CHG001

Sub 11-4-15

JG BG 11-4-15

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Cut (1) blank 18.00" as per Dwg D3033 from D3033-144 extrusion. □ Debur
blank and identify as D3033-1.

pulled from 2/15

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68447

Wednesday, April 13, 2011 2:29:11 PM

Page 2

Item ID: D350-689-015

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Modification

Start Date: 4/13/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11-04-13
MF
A
11/11/14 SP 10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68447

Wednesday, April 13, 2011 2:29:11 PM



Page 3

Item ID: D350-689-015

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Modification

Start Date: 4/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Suloxlig



170



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP d350-689-015 Location: _____ □ PPP Rev: _____

0.00

0.00

C444/11/18 ①

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/18 J

MF

11-04-18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 2:29:03 PM

Page 1

Work Order ID: 68447

Parent Item: D350-689-015

Parent Item Name: Seat Modification

Start Date: 4/13/2011

Required Date: 4/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A ☐ 04.03.25 ☐ New Issue ☐ KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10L Washer	NAS1149D0332J	Purchased	No			160	Each	0.0000	3	3			
AN960JD516 Washer	NAS1149D0563J	Purchased	No			160	Each	0.0000	4	4			
D3029-1 Spring		Manufactured	No			160	Each	4.0000	2	2			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST034	4							
					46848	4							
D3030-1 Lock		Manufactured	No			160	Each	4.0000	2	2			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST031	4							
					50363	4							
D3033-1 Seat Track		Manufactured	No			160	Each	21.6400	1.5	1.5			
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST489A	21.64							
					30209	0.5							
					58045	21.14							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 2:29:04 PM

Page 2

Work Order ID: 68447



Parent Item: D350-689-015



Parent Item Name: Seat Modification

Start Date: 4/13/2011

Required Date: 4/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3059-1

Manufactured No

160

Each

22.0000

4



Stud



SP

Location

Loc Qty

Loc Code

ST031

22

22347

2

46491

20

D3060-1

Manufactured No

160

Each

32.0000

4



Bushing



20
20
4
SP

Location

Loc Qty

Loc Code

ST032

32

24725

32

D3061-1

Manufactured No

160

Each

21.0000

4



Radius Block



4
4
SP

Location

Loc Qty

Loc Code

ST032

21

22349

21

MS20426AD3-6

Purchased No

160

Each

3,949.000

8



Rivet



4
SP 11/4/14

Location

Loc Qty

Loc Code

ST316

3949

105055

379

116289

3570

4
SP

Wednesday, April 13, 2011 2:29:04 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 2:29:04 PM

Page 3

Work Order ID: 68447

Parent Item: D350-689-015

Parent Item Name: Seat Modification

Start Date: 4/13/2011

Required Date: 4/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

160

Each

765.0000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

765

115594

5

116105

500

116548

260

MS21059L3

Purchased

No

160

Each

10.0000

4

4



Nut Plate

Location

Loc Qty

Loc Code

ST302

10

116706

10

MS24693-S273

Purchased

No

160

Each

859.0000

1



Screw

Location

Loc Qty

Loc Code

ST288

859

100151

759

117291

100

MS27039-1-10

Purchased

No

120

Each

80.0000

1



Screw

Location

Loc Qty

Loc Code

ST291

80

115935

80

Wednesday, April 13, 2011 2:29:04 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9222	REV. A SHEET 1 OF 2
DATE 01.11.16		TITLE SEAT MODIFICATION KIT	SCALE NTS
A	01.11.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-689 REV. A

REF. CANADIAN STC: SH98-36
US FAA STC: SR00912NY

REFERENCE ONLY

INTRODUCTION

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ALLOW CUSTOMERS TO MODIFY THE REGULAR EUROCOPTER SEATS (REF. P/N 350A77-1080-05, 350A77-0068-0202 & 350A77-0068-01) FOR COMPATIBILITY WITH THE DART D350-689-013 FLOOR PROVISIONS KIT THAT GETS INSTALLED WITH THE D350-689-011 DUAL HIGH BACK SEAT. THE D350-689-015 KIT ALLOWS CUSTOMERS TO QUICKLY SWITCH BACK AND FORTH BETWEEN THE EUROCOPTER SEAT AND THE DART SEAT.

PARTS LIST

Qty -015	Part Number	Description
X	D350-689-015	SEAT MODIFICATION KIT
2	D3029-1	SPRING
2	D3030-1	LOCK
1	D3033-1	SEAT TRACK
4	D3059-1	STUD
4	D3060-1	BUSHING
4	D3061-1	RADIUS BLOCK
3	AN960JD10L	WASHER
4	AN960JD516	WASHER
8	MS20426AD3-6	RIVET
4	MS21042L5	NUT (or MS21042-5)
4	MS21059L3	NUTPLATE
1	MS24693-S273	SCREW
3	MS27039-1-10	SCREW

INSTALLATION PROCEDURE

1. INSTALL STUD FITTINGS ON EUROCOPTER SEAT SLIDES (REF. 350A77-1116-2401 & 350A77-1117-24) AS SHOWN IN FIGURE 2. THE CENTER OF THE STUD FITTINGS SHOULD BE 14.0" (356 mm) APART.
2. REMOVE ANY EXISTING RIVETS AT STA 50.94 (1294 mm) AND STA 70.47 (1790 mm) THAT INTERFERE WITH INSTALLATION OF SEAT TRACKS ON EXISTING OUTBOARD RUBBING STRIP (LBL 17.16).
3. LOCATE AFT END D3033-1 AT STA 70.47 AND CENTERED ON OUTBOARD RUBBING STRIP.
4. TRANSFER DRILL $\varnothing 0.128"$ FROM FLOOR TO D3033-1 SEAT TRACK USING THE RIVET HOLES THAT WILL MOST CLOSELY GIVE THE DIMENSIONS SHOWN IN FIGURE 1.
5. OPEN SEAT TRACK AND A/C FLOOR HOLES TO $\varnothing 0.191"$ AND COUNTERSINK HOLE FOR MS24693-S273 SCREW IN SEAT TRACK.
6. TOUCH UP ALL BARE METAL PER IIN-D350-689 REV. A.
7. INSTALL MS21059L3 NUTPLATES WITH MS20426AD3-6 RIVETS (4 PLACES) PER FIGURE 1.
8. INSTALL D3033-1 SEAT TRACK PER FIGURE 1.
9. CHECK FIT OF MODIFIED SEAT.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

DATE: NOV. 16 2001
CERT. NO.: SH98-36
ISSUE NO.: #4

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9222	REV. A SHEET 1 OF 2
DATE 01.11.16		TITLE SEAT MODIFICATION KIT	SCALE NTS
A	01.11.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D350-689 REV. A

REF. CANADIAN STC: SH98-36
US FAA STC: SR00912NY

INTRODUCTION

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ALLOW CUSTOMERS TO MODIFY THE REGULAR EUROCOPTER SEATS (REF. P/N 350A77-1080-05, 350A77-0068-0202 & 350A77-0068-01) FOR COMPATIBILITY WITH THE DART D350-689-013 FLOOR PROVISIONS KIT THAT GETS INSTALLED WITH THE D350-689-011 DUAL HIGH BACK SEAT. THE D350-689-015 KIT ALLOWS CUSTOMERS TO QUICKLY SWITCH BACK AND FORTH BETWEEN THE EUROCOPTER SEAT AND THE DART SEAT.

PARTS LIST

Qty -015	Part Number	Description
X	D350-689-015	SEAT MODIFICATION KIT
2	D3029-1	SPRING
2	D3030-1	LOCK
1	D3033-1	SEAT TRACK
4	D3059-1	STUD
4	D3060-1	BUSHING
4	D3061-1	RADIUS BLOCK
3	AN960JD10L	WASHER
4	AN960JD516	WASHER
8	MS20426AD3-6	RIVET
4	MS21042L5	NUT (or MS21042-5)
4	MS21059L3	NUTPLATE
1	MS24693-S273	SCREW
3	MS27039-1-10	SCREW

INSTALLATION PROCEDURE

1. INSTALL STUD FITTINGS ON EUROCOPTER SEAT SLIDES (REF. 350A77-1116-2401 & 350A77-1117-24) AS SHOWN IN FIGURE 2. THE CENTER OF THE STUD FITTINGS SHOULD BE 14.0" (356 mm) APART.
2. REMOVE ANY EXISTING RIVETS AT STA 50.94 (1294 mm) AND STA 70.47 (1790 mm) THAT INTERFERE WITH INSTALLATION OF SEAT TRACKS ON EXISTING OUTBOARD RUBBING STRIP (LBL 17.16).
3. LOCATE AFT END D3033-1 AT STA 70.47 AND CENTERED ON OUTBOARD RUBBING STRIP.
4. TRANSFER DRILL Ø0.128" FROM FLOOR TO D3033-1 SEAT TRACK USING THE RIVET HOLES THAT WILL MOST CLOSELY GIVE THE DIMENSIONS SHOWN IN FIGURE 1.
5. OPEN SEAT TRACK AND A/C FLOOR HOLES TO Ø0.191" AND COUNTERSINK HOLE FOR MS24693-S273 SCREW IN SEAT TRACK.
6. TOUCH UP ALL BARE METAL PER IIN-D350-689 REV. A.
7. INSTALL MS21059L3 NUTPLATES WITH MS20426AD3-6 RIVETS (4 PLACES) PER FIGURE 1.
8. INSTALL D3033-1 SEAT TRACK PER FIGURE 1.
9. CHECK FIT OF MODIFIED SEAT.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:
D. SHEPHERD (DE # 02)

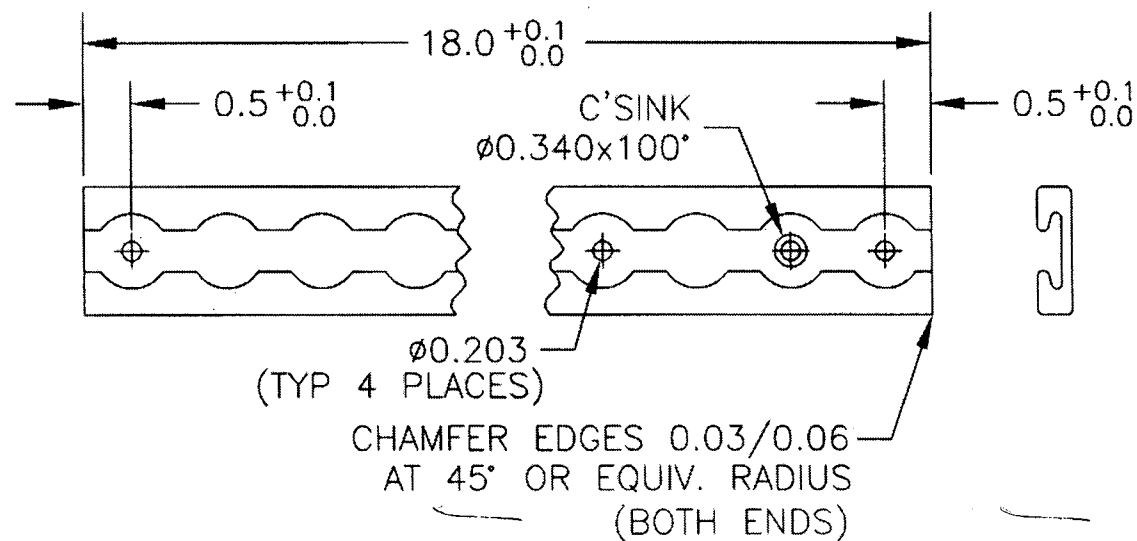
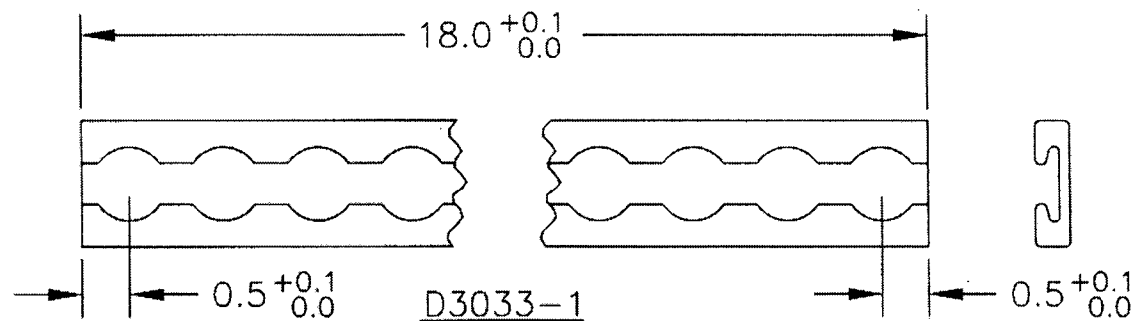
DATE: NOV. 16 2001
CERT. NO.: SH98-36
ISSUE NO.: #4

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

AI ~~KJ~~ 03.08.25 NOTE 1 MODIFIED

SPECIFICATION CONTROL DRAWING



(CAN MAKE FROM D3033-1)

D3033-1 & D3033-3